

Work Order ID 58841

Wednesday, May 19, 2010 1:37:45 PM



Page 1

Item ID: D3705-7

Accept



Setup Start



Revision ID:

Item Name: MAIN PANEL

Stop



Start Date: 5/19/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-5-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3705

D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3705

Dwg Rev: BProg Rev: B

2- Deburr if necessary

6061 .063

③

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-6-2

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 106662

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									

(X3) 10/26/07 JB

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Powdercoat

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

11/12588

0.00

H 10/06/10

X3

Ø

Powder Coating

Memo

0.00

START TIME: 7:00AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 7:30AM

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

3

bk 10-6-10

180



Packaging

Packaging

Identify as per dwg & Stock Location: 84

0.00

Memo

0.00

10-6-10 (3x) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Required Date: 5/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/14

CZ10/6/11

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 19, 2010 1:37:50 PM

Page 1

Work Order ID: 58841



Parent Item: D3705-7



Parent Item Name: MAIN PANEL

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:A 09-01-09 rev.c as per dwg DD verified by:EC IPP Rev:B as
per dwg RevD DD 10.04.27 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	134.9000	0.35	1.2		
6061-T6 .063 Sheet												



B10-6-2

Location

Loc Qty

Loc Code

MAT21

134.9

113608

134.9

113609

⑤

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58841
Description: Face Plate		Part Number:	D3705-7
Inspection Dwg: D3705	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.201	+0.005/-0.001	0.204	✓			
Ø1.950	+0.012/-0.001	1.951	✓			
Ø3.150	+0.012/-0.001	3.150	✓			
0.295	+/-0.010	0.296	✓			
0.368	+/-0.010	0.369	✓			
1.445	+/-0.010	1.446	✓			
2.520	+/-0.010	2.523	✓			
3.222	+/-0.010	3.225	✓			
3.295	+/-0.010	3.294	✓			
3.59	+/-0.030	3.595	✓			
0.700	+/-0.010	0.701	✓			
0.573	+/-0.010	0.573	✓			
1.125	+/-0.010	1.125	✓			
8.125	+/-0.010	8.125	✓			
8.625	+/-0.010	8.623	✓			
11.050	+/-0.010	11.050	✓			
12.927	+/-0.010	12.927	✓			
13.50	+/-0.030	13.50	✓			
0.063	+/-0.010	0.059	✓			

Measured by:	JB	Audited by:	S	Prototype Approval:	N/A
Date:	10-6-2	Date:	10/06/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.02.04	New Issue	KJ	JA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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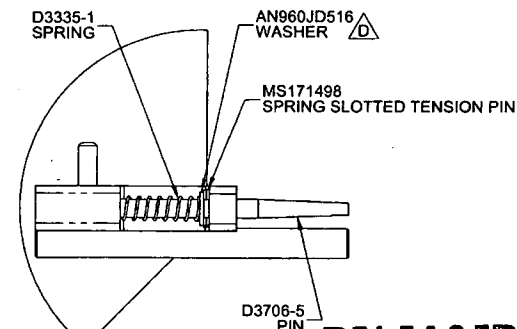
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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D3705-041	INSTRUMENT PANEL ASS'Y
5	1	D3335-1	SPRING
6	1	D3705-043	INSTRUMENT PANEL WELDMENT
7	1	D3705-5	ACCESS PANEL
8	1	D3706-5	PIN
9	2	D3707-3	MOUNTING LUG
13	4	AN526C1032R6	SCREW
14	1	AN960JD516	WASHER
15	1	MS171498	SPRING SLOTTED TENSION PIN
17	14	MS21075L3	NUT PLATE
18	4	MS24693C272	SCREW
19	28	CR1122-3-02.5	RIVET





△

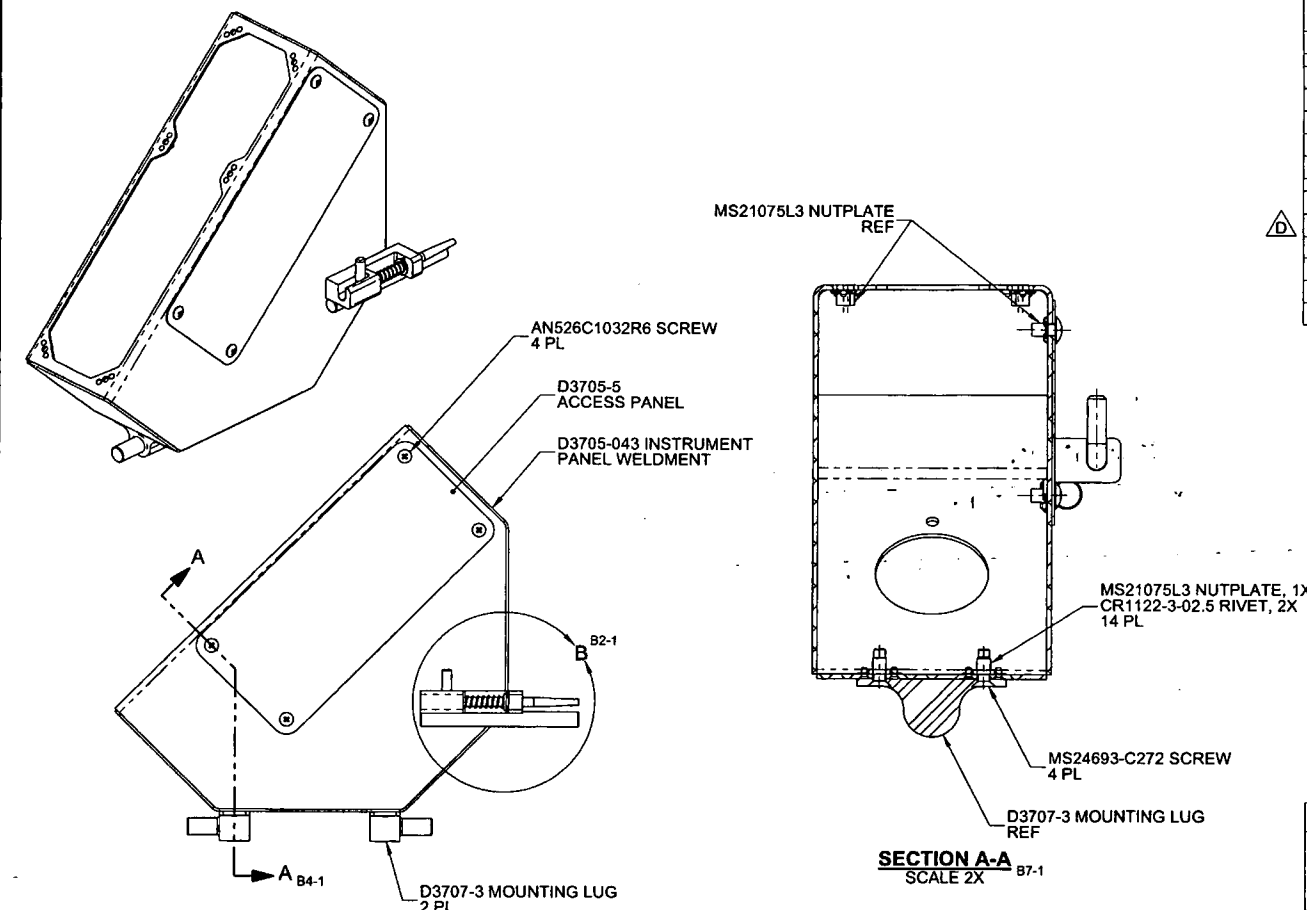


DETAIL B
SCALE 2X B6-1

RELEASED
2010-04-26

D	ITEM 14 WAS AN960JD416 (ZN D3-1 AND C1-1). REASON: NCR#10-017.	MB	10.04.15
C	ADDED D3705-7/9/11 (SHEET 6); REMOVED MS35589-156 GROMMET; 9.31 AND 12.66 WERE 9.36 AND 12.61 (ZN B6-3); Ø 1.90 WAS 1.50 (ZN D5-4); ADDED Ø 0.204 HOLE (ZN D5-4); CR1122-3-02.5 WAS MS20426AD3-3. REASON: COMPLETED DESIGN OF FACE PLATES REQUIRED TO MOUNT INSTRUMENTS.	MB	08.11.20
B	ADDED MS35489-156; QTY. 14 MS21075L3 WAS QTY. 8; QTY. 28 MS20426AD3-3 WAS QTY. 16; MS171498 WAS TP-2; AN526C1032R6 WAS MS27039-1-09 & AN960JD10L (ZN D3-1); REDESIGNED D3705-1F FLAT PATTERN (ZN B6-3). REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT	MB	08.08.07
A	NEW ISSUE	MB	08.05.26
REV.	DESCRIPTION	BY	DATE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3705	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASS'Y	
DATE	10.04.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION A-A
SCALE 2X B7-1

D3705-041 INSTRUMENT PANEL ASS'Y

- D3705-041 NOTES:**
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-041" USING WHITE FINE POINT PERMANENT INK MARKER
7) WEIGHT: 3.00 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58841

2010-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

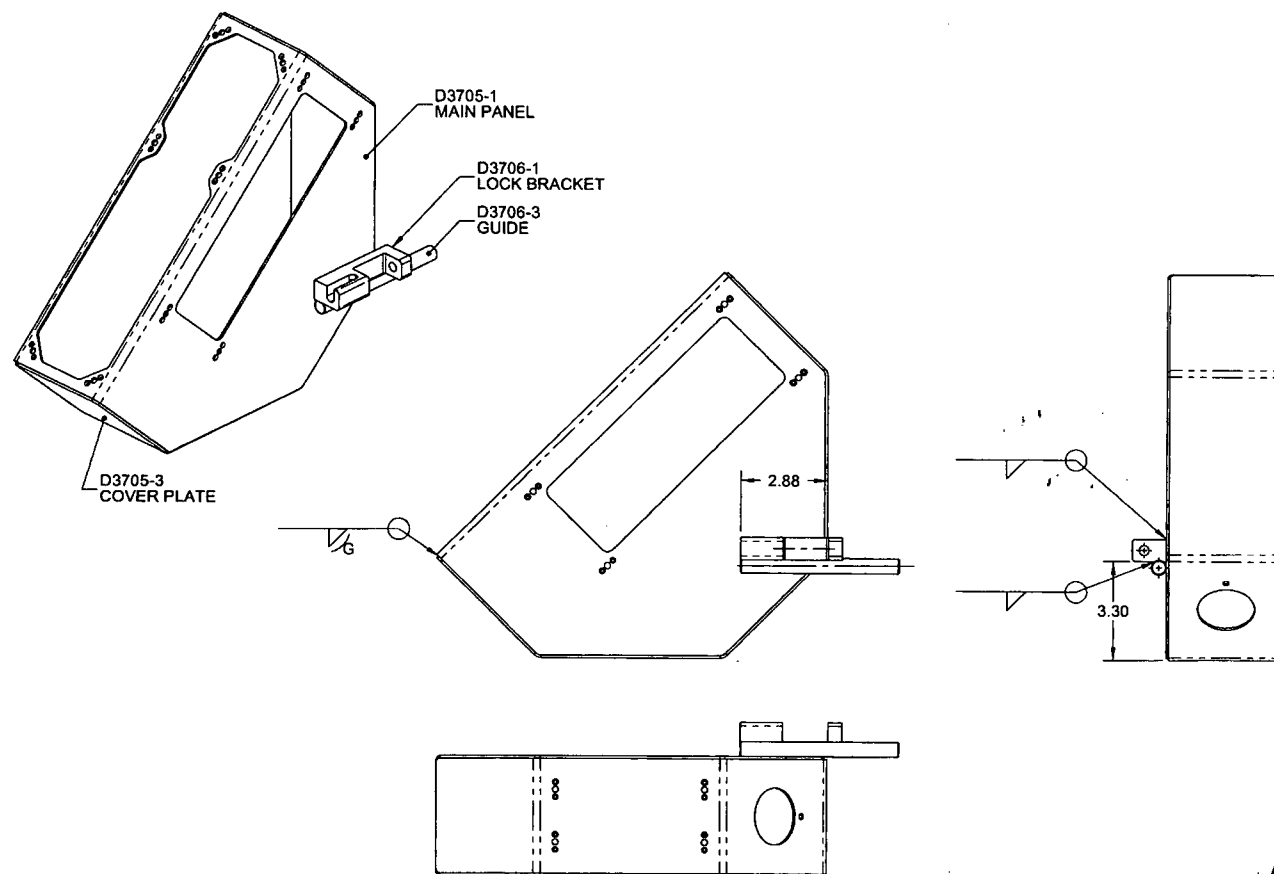
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	-043 QTY.	P/N	DESCRIPTION
1	X	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-1	MAIN PANEL
4	1	D3705-3	COVER PLATE
5	1	D3706-1	LOCK BRACKET
6	1	D3706-3	GUIDE



D3705-043 INSTRUMENT PANEL WELDMENT

D3705-043 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.90 lbs
- 8) WELDING: PER DART QSI 004

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		TITLE	SHEET 2 OF 6
APPROVED		INSTRUMENT PANEL ASSY	SCALE
DE APPR.			NTS
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RELEASED
2010-04-26

W/O 58841

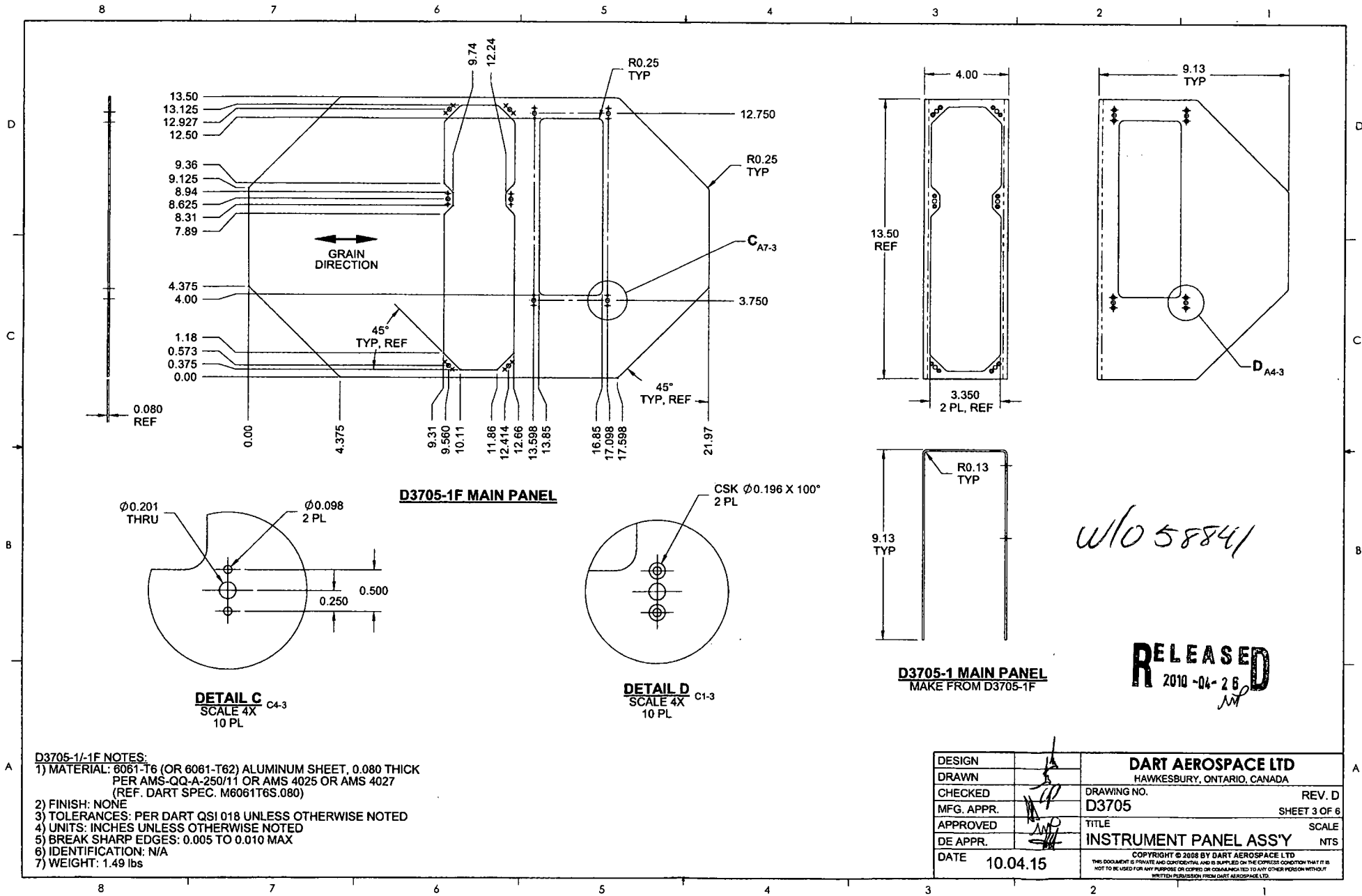
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3705-1/-1F NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.49 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3705	SHEET 3 OF 6
APPROVED		TITLE	SCALE
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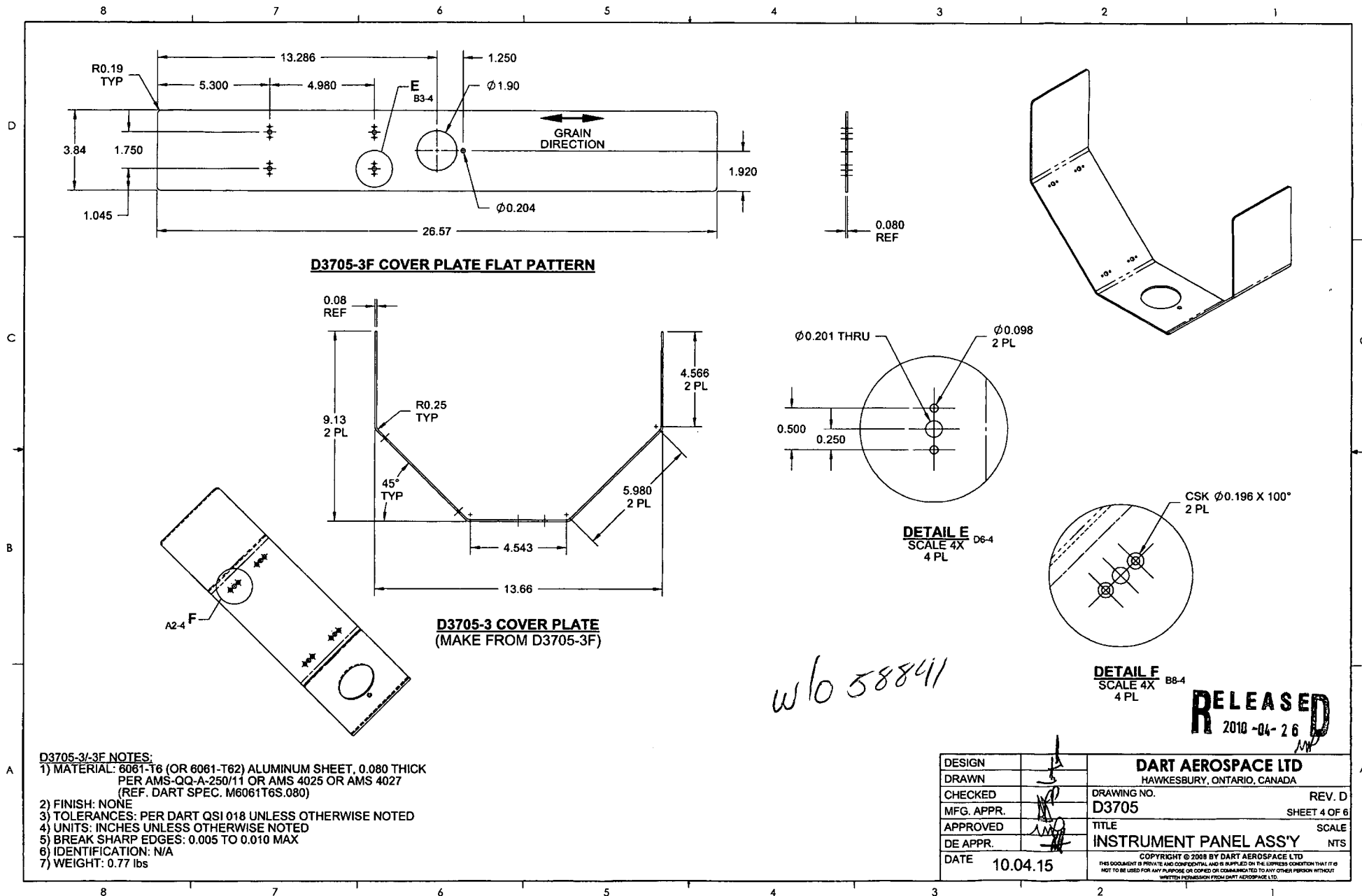
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Dart Aerospace Ltd

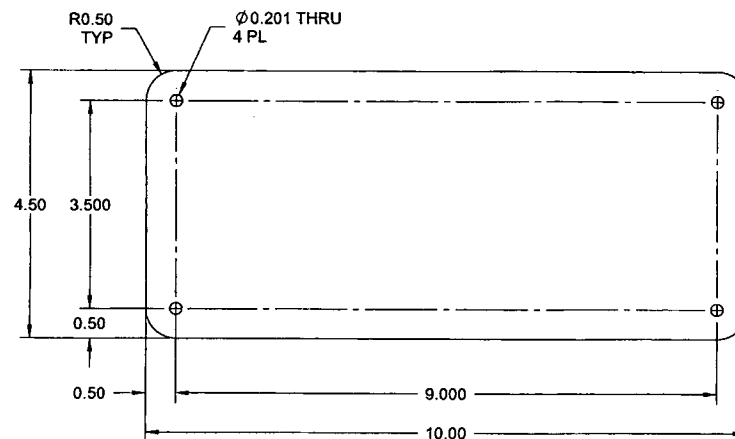
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NOTE: Date & initial all entries



D3705-5 ACCESS PANEL

W10 58841

RELEASED
2010-04-26

D3705-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-5" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.17 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3705	SHEET 5 OF 6
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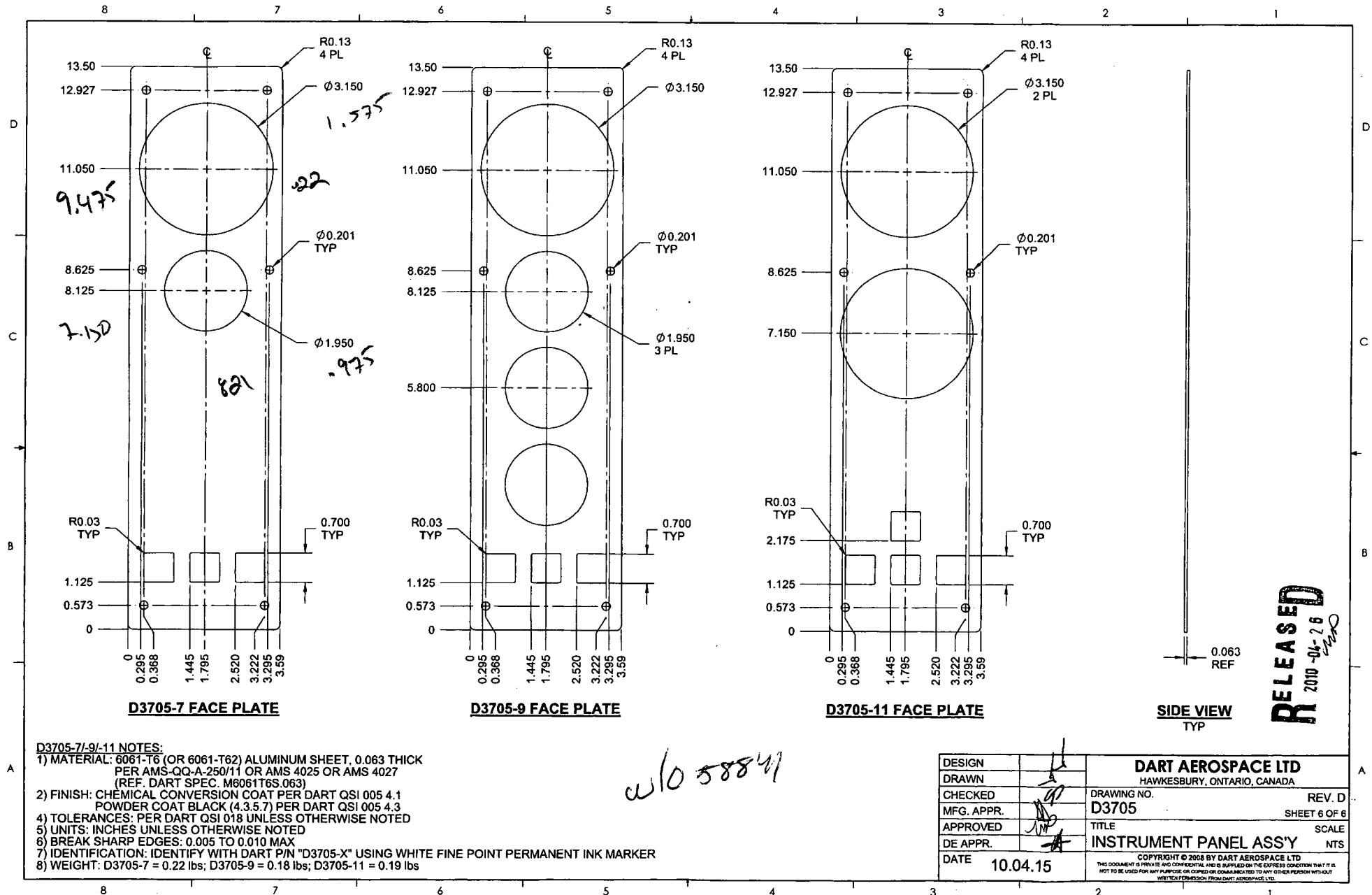
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